

## Claims

1. Device for producing concrete molded blocks, having a molding insert comprising one or more mold cavities and having a mold frame, in order to hold the molding insert in a molding machine, particularly during a vibration process, characterized in that at least one accommodation for connecting a sensor with the molding insert, for local determination of a movement variable of the molding insert, is configured on the molding insert.
2. Device according to claim 1, characterized in that the accommodation includes a recess between two surfaces of molding insert and mold frame that face one another.
3. Device according to claim 2, characterized in that the recess is delimited on at least four sides by surfaces of the mold frame and the molding insert.
4. Device according to one of claims 1 to 3, characterized in that the recess has an expanse of at least 10 mm in all directions.

5. Device according to one of claims 2 to 4, characterized in that the recess is open towards the side and/or towards the bottom.
6. Device according to one of claims 1 to 5, characterized in that the accommodation is offset from an edge-position mold cavity of the molding insert towards its edge.
7. Device according to one of claims 1 to 6, characterized in that a recess is made in the outside wall of the molding insert for the accommodation.
8. Device according to one of claims 1 to 7, characterized in that the accommodation contains a projection that faces the mold frame, on an outside wall of the molding insert.
9. Device according to claim 8, characterized in that the projection is configured as a material-homogeneous continuation of the molding insert.
10. Device according to claim 8, characterized in that the continuation is set onto the molding insert, particularly welded on.

11. Device according to one of claims 8 to 10, characterized in that the projection projects into a depression of the mold frame.
12. Device according to one of claims 8 to 11, characterized in that the mold frame has a hole through a wall in the position of the projection.
13. Device according to one of claims 1 to 12, characterized in that the accommodation is removed by maximally 100 mm, particularly maximally 50 mm, from a corner of the molding insert, along an outside edge of the molding insert.
14. Device according to one of claims 1 to 13, characterized in that the accommodation is disposed at a distance from the edge of the molding insert, between two adjacent mold cavities.
15. Device according to claim 14, characterized in that a guide channel leads from the accommodation to a side surface of the molding insert.

16. Device according to one of claims 1 to 12, characterized in that the molding insert is structured in one piece.
17. Device according to one of claims 1 to 13, characterized in that the molding insert is structured with material homogeneity.
18. Device according to one of claims 1 to 17, characterized in that at least part of the walls of the molding insert are structured to be double-shelled.
19. Device according to one of claims 1 to 18, characterized in that a guide channel that leads to the accommodation is configured in the mold frame.
20. Device according to one of claims 1 to 19, characterized in that the accommodation has a threaded bore.
21. Device according to one of claims 1 to 20, characterized in that the accommodation has a threaded pin.

22. Device according to one of claims 1 to 21, characterized in that damping means, particularly rubber-elastic material, is/are inserted between molding insert and mold frame.
23. Device according to one of claims 1 to 22, characterized in that four accommodations are provided along the circumference of the molding insert.
24. Device according to one of claims 1 to 19, characterized in that an accommodation is provided approximately in the center of the surface of the molding insert.
25. Arrangement having a device according to one of claims 1 to 24, and a sensor connected with the molding insert by means of the accommodation.
26. Arrangement according to claim 25, characterized in that the sensor is releasably connected with the molding insert, in destruction-free manner, in the accommodation.
27. Arrangement according to claim 26, characterized in that the molding insert is held in the mold frame, movable to a slight extent relative to the latter, during the vibration process.

28. Arrangement according to claim 27, characterized in that at least one additional movement sensor is disposed on the mold frame, and that an evaluation unit determines at least one movement variable of the relative movement between mold frame and molding insert.
29. Method for determining at least one movement variable of a mold comprising a mold frame and a molding insert, for producing concrete molded blocks, with the inclusion of a vibration process, characterized in that during the vibration process, both a first movement variable for the movement of the molding insert and a second movement variable for the movement of the mold frame are measured, and that a further movement variable for the relative movement of mold frame and molding insert is determined from linking the first and second movement variable.